

54435 Deren

Work Order ID 53864



Page 1

November 20, 2009 1:27:33 PM

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *RV*

Date: *09/11/20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

u
005 per ECU 09-702

DST 9490

8
02/02/08

HJ for BG 09/11/23

53864

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53864

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Revision ID: F

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Start Date: 20/11/2009 Start Qty: 1.00



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

0.00

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

m12507

10-Grind welds flush as per Dwg D2750

BE 09/11/24

BE 09/11/25

BE 09/11/24

BE 09/11/25

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

12- Scribe batch# inside per dwg D2750

BE 09/11/25

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

⇒ 8 09/11/25



130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 09/11/25



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 11/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BB (1) 09/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Skidtube LH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>1112395</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> exp. date: <u>01/21/10</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>m112507</u> <u>B6</u> <u>09/12/02</u>								
	9-Grind welds flush as per Dwg D2750								
	10-Spot face ground handling holes section (total of 4 places perside) as per dwg D2750								

11/9/12/11

AWM 9-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53864

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53864

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidcube LH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

=> M 09/12/09

(K)

Q

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M112148

=> M 09/12/09

(X)

Q

START TIME: 9:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:00AM

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

BR 09-12-7

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
	HandFinish	0.00				(X)	9		
Hand Finishing	Memo 1- Install inserts as per Dwg D2750								
230	HandFinishing	0.00							
	HandFinish	0.00				(X)	8		
Hand Finishing	Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: <u>N/A</u> 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M1112345</u> EXP DATE: <u>10/00</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M1101223</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M1104251</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53864

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Item ID: D350-636-011

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Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 8 09/12/09

(4)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

9/12/09

sy

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

2) 8 09/12/09

(4)

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 53864

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280		0.00							
	QC21 - Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

09/12/09

09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2594-3RevC Manufactured

No

230

Each

854.0000

8.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

827

2562

827

110

Each

67.0000

1.0000

D2744RevC

Manufactured

No



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

67

44892

1

47488

30

51922

36

110

Each

0.0000

1.0000

D2600-3-BENTRevD1

Manufactured

No



Extrusion Bent

X8 9/12/09

1 8/11/09

Q 52346 8/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2743RevB Manufactured

No

160

Each

355.0000

8.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

110

50281

50

51913

60

Main Warehouse

ST

245

44891

2

45555

57

48275

1

52310

185

B BE 09/12/12

D2739RevD Manufactured

No

160

Each

1.0000

1.0000



350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

47124

1

B57900

M 9/12/11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3490-3RevA

Manufactured

No

160

Each

65.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

45560

1

48276

31

51930

33

4 BE 09/12/02

D3490-1RevA

Manufactured

No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45338

2

47657

22

48277

48

51932

40

4 BE 09/12/02

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-225 Purchased



Insert

No			220	Each	7,324.000	38.0000						
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Warehouse	Loc Qty	Loc Code
Main Warehouse		
ST	7324	
107441	16	
110768	7308	

D3492-041RevC Manufactured



Plug Assembly

No			230	Each	140.0000	8.0000						
----	--	--	-----	------	----------	--------	--	--	--	--	--	--



Warehouse	Loc Qty	Loc Code
Main Warehouse		
ST	140	
51584	140	

D3793-3RevA Manufactured



Wearshoe

No			230	Each	23.0000	1.0000						
----	--	--	-----	------	---------	--------	--	--	--	--	--	--



Warehouse	Loc Qty	Loc Code
Main Warehouse		
ST	23	
51592	12	
51903	11	

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Shop Packet Print

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x38 24 09/12/07

x8 24 09/12/07

x1 24 09/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:



Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN8C35A Purchased



BOLT

No			230	Each	144.0000	1.0000						
----	--	--	-----	------	----------	--------	--	--	--	--	--	--

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

144

102180

1

106896

1

110105

48

110847

94

D3793-1RevA

Manufactured



Wearshoe

No			230	Each	27.0000	1.0000						
----	--	--	-----	------	---------	--------	--	--	--	--	--	--

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

40551

1

51597

16

51906

10

X1 24 09/12/07

X1 24 09/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3488-041RevB Manufactured

No

230

Each

18.0000

1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47348

18

230

Each

28.0000

1.0000

D3794-3RevA

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

24

51598

12

51907

12

Main Warehouse

ST

4

46531

2

47440

1

47722

1

X1 24 09/12/09

X1 12 09/12/09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Placement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	----------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN6C44A Purchased



BOLT

No 230 Each 180.0000 4.0000



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 2

103964 2

Main Warehouse

ST 178

110105 4

110155 14

110665 1

111605 50

111649 50

112720 9

113121 50

x4 09/12/07

MS21083C8 Purchased



NUT

No 230 Each 72.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 72

110584 5

111424 2

112492 15

113149 50

x1 09/12/07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	23.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP10	18	
51607	18	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

21 11/09/12/09

D3631-1RevA

Manufactured

No

230

Each

221.0000

8.0000

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	221	
38139	6	
45353	16	
47437	1	
62693	198	

28 11/09/12/09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:



Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3791-1RevA Manufactured



Wearplate

No			230	Each	19.0000	1.0000						
----	--	--	-----	------	---------	--------	--	--	--	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

51610

7

Main Warehouse

ST

12

51909

12

AN960C10L

Purchased



washer

No			230	Each	2,658.000	38.0000						
----	--	--	-----	------	-----------	---------	--	--	--	--	--	--

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

2558

112116

548

112612

1010

112933

1000

1 x 91 09/12/07

y38 14 09/12/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube-LH

Comments:



Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	402.0000	8.0000			
Bushing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	88	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
43754	2	
44893	33	
45556	1	
48278	29	
Main Warehouse		
ST46	314	
51537	70	
51910	63	
52311	181	

x8 ul 09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:







Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status																														
AN3C5A 		Purchased	No			230	Each	1,118.000	34.0000																																	
Bolt																																										
<table><tr><th><u>Warehouse</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td><u>Location</u></td><td></td><td></td></tr><tr><td>Main Warehouse</td><td></td><td></td></tr><tr><td>ST</td><td>1118</td><td></td></tr><tr><td>111424</td><td>8</td><td></td></tr><tr><td>111707</td><td>69</td><td></td></tr><tr><td>112314</td><td>1</td><td></td></tr><tr><td>N2641</td><td>440</td><td></td></tr><tr><td>113121</td><td>300</td><td></td></tr><tr><td>113149</td><td>300</td><td></td></tr></table>													<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	<u>Location</u>			Main Warehouse			ST	1118		111424	8		111707	69		112314	1		N2641	440		113121	300		113149	300	
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																								
<u>Location</u>																																										
Main Warehouse																																										
ST	1118																																									
111424	8																																									
111707	69																																									
112314	1																																									
N2641	440																																									
113121	300																																									
113149	300																																									
D3537-1RevC 		Manufactured	No			230	Each	198.0000	3.0000																																	
Wearpad																																										
<table><tr><th><u>Warehouse</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td><u>Location</u></td><td></td><td></td></tr><tr><td>Main Warehouse</td><td></td><td></td></tr><tr><td>FP</td><td>2</td><td></td></tr><tr><td>48288</td><td>2</td><td></td></tr><tr><td>Main Warehouse</td><td></td><td></td></tr><tr><td>FP17</td><td>196</td><td></td></tr><tr><td>51678</td><td>91</td><td></td></tr><tr><td>51679</td><td>105</td><td></td></tr></table>													<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	<u>Location</u>			Main Warehouse			FP	2		48288	2		Main Warehouse			FP17	196		51678	91		51679	105				
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																								
<u>Location</u>																																										
Main Warehouse																																										
FP	2																																									
48288	2																																									
Main Warehouse																																										
FP17	196																																									
51678	91																																									
51679	105																																									

x34 Ml

09/12/07

x3 Ml

09/12/07

X34 M 09/12/09

X3 M 09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L  WASHER		Purchased	No			230	Each	260.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	260	
104093	2	
107520	4	
110139	29	
110372	10	
110584	100	
111424	115	

Y1 09/12/07

D3492-043RevC

Manufactured

No



Plug Assembly

230 Each 84.0000 8.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	84	
52309	84	

X8 09/12/07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:



Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C6A
BOLT
Purchased

No 230 Each 904.0000 4.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

904

111982

904

NAS1611-013
O-RING
Purchased

No 230 Each 138.0000 8.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

138

106513

11

111424

20

111758

107

24 21 09/12/07

28 21 09/12/07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	24.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

14

51663

1

51927

13

Main Warehouse

ST

10

52589

10

D3794-1RevA

Manufactured

No

230

Each

22.0000

1.0000



Gasket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51928

12

Main Warehouse

ST

10

46530

1

47212

2

51668

7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21043-6 Purchased

No

230

Each

1,040.000

4.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1040

111424

40

112314

1000

x4 08/12/07

D3493-1RevA

Manufactured

No

260

Each

69.0000

2.0000



Washer

9/12/07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69

44902

2

47710

67

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:



Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21083C8

Purchased

No

260

Each

72.0000

2.0000

NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

110584

5

111424

2

112492

15

113149

50

AN8C21A

Purchased

No

260

Each

114.0000

2.0000

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

114

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

111684

4

112720

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C816L

Purchased

No

260

Each

260.0000

2.0000



WASHER



9/12/8 5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

260

104093

2

107520

4

110139

29

110372

10

110584

100

111424

115

2

AN51515H3L

Purchased

No

230

Each

266.0000

4.0000



WASHER



Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

226

110450

2

111819

224

14 12 09/12/07

November 20, 2009 12:42:47 PM

Shop Packet Print

Page 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:42:47 PM

Page 18

Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:



Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741RevC

Manufactured

No

260

Each

53.0000

1.0000



Blade, 350 Skidtube



9/12/7 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

20770

0

45320

1

47113

12

51931

40

1 SP

D3532-1RevA

Manufactured

No

260

Each

93.0000

2.0000



Spacer



9/12/7 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

44904

2

52321

91

2 SP

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Page 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:42:47 PM

Page 19

Work Order ID: 53864

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L  WASHER		Purchased	No			260	Each	81.0000	2.0000		9/12/8 84	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

81

107581

34

108964

1

~~111650~~

46

B113148

54363

2 sep

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

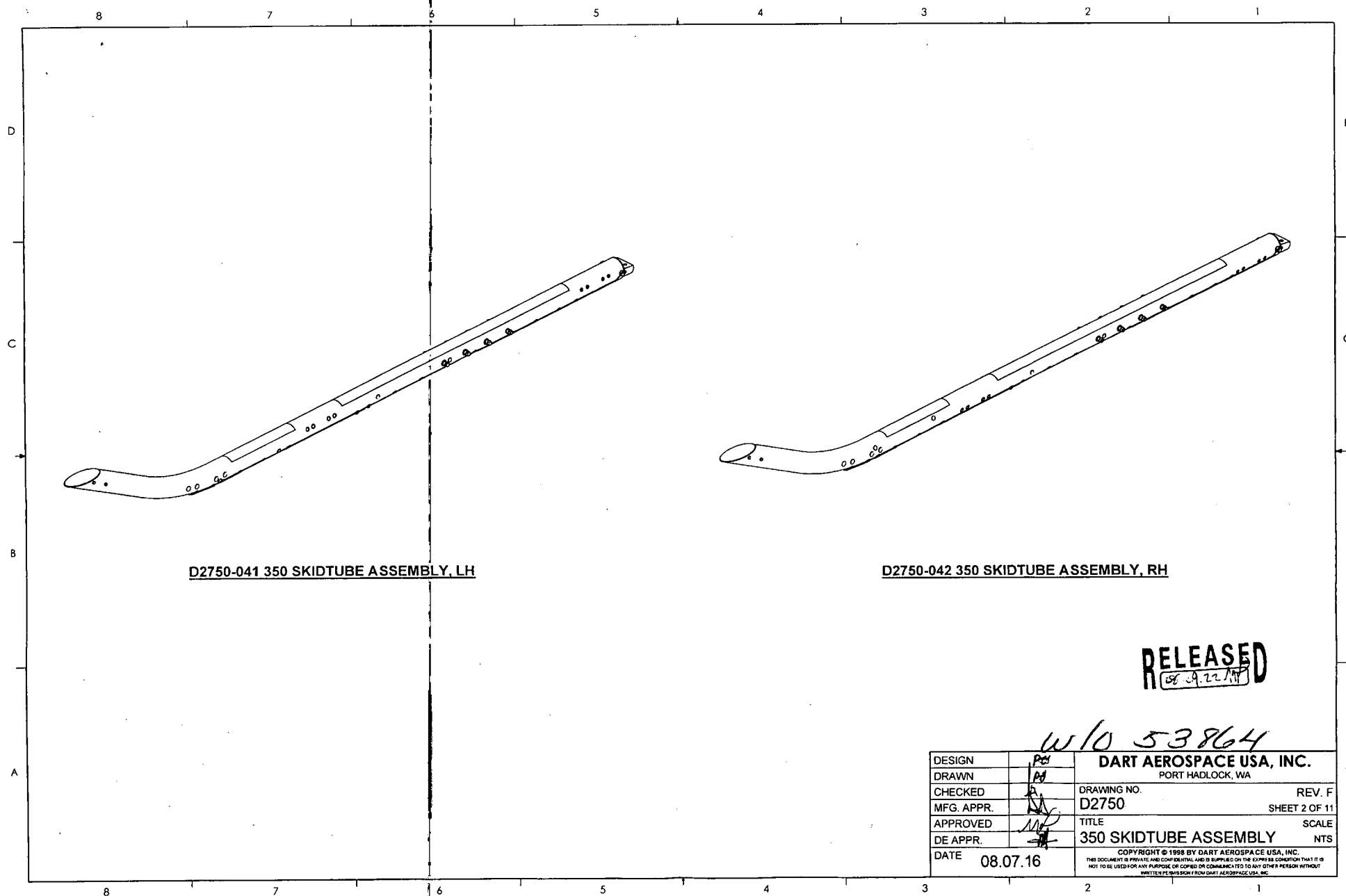
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WITHOUT NOTICE
WORK ORDER

NO. 53864

BL 09-11-20

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3532-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/FT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RD	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RD		
CHECKED	LD	DRAWING NO.	REV. F
MFG. APPR.	LD	D2750	SHEET 1 OF 11
APPROVED	LD	TITLE	SCALE
DE APPR.	LD	350 SKIDTUBE ASSEMBLY	NTS
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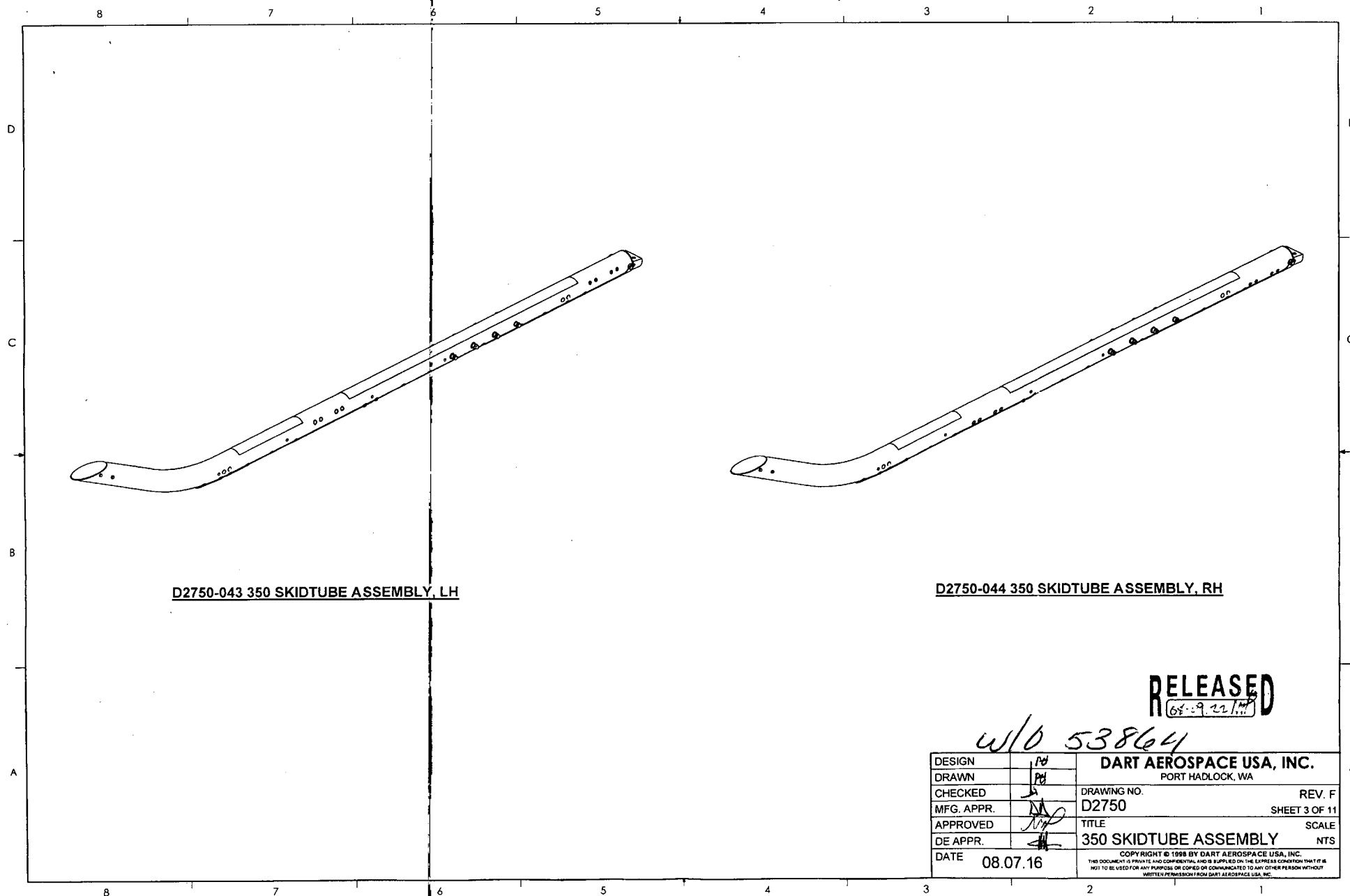
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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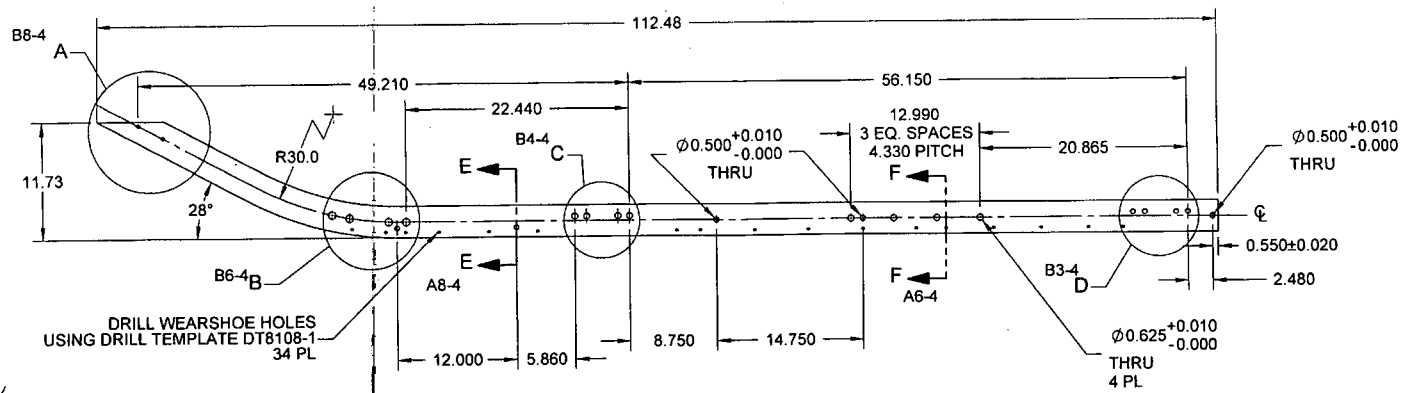
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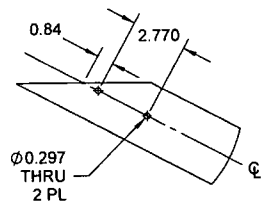
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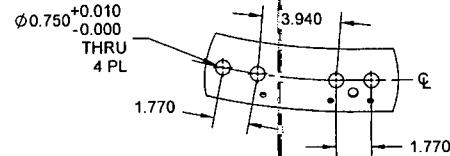
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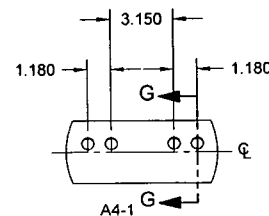
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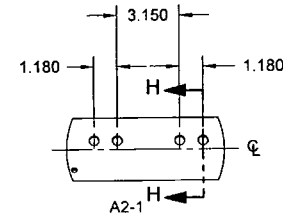
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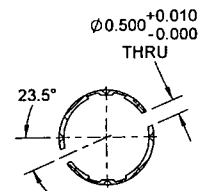
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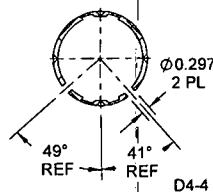
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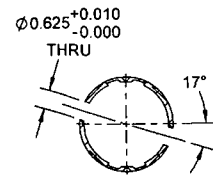
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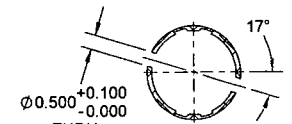
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SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



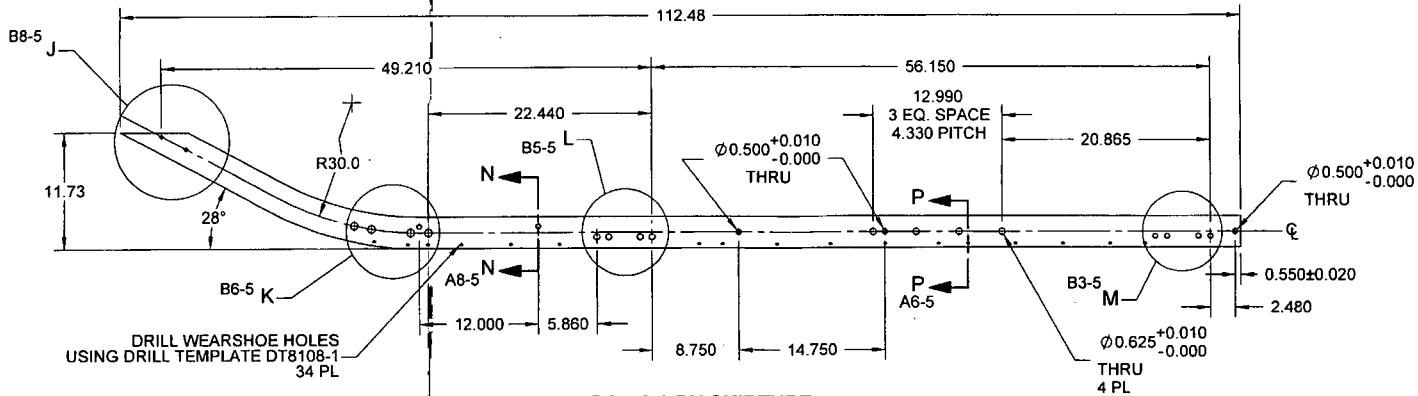
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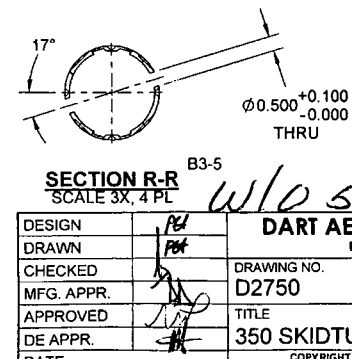
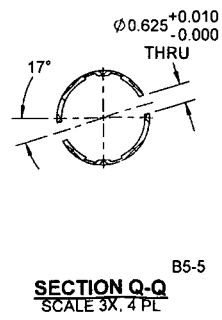
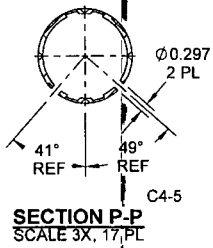
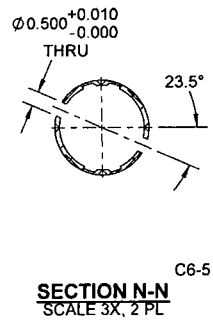
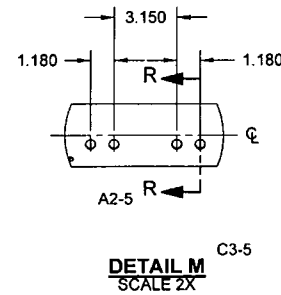
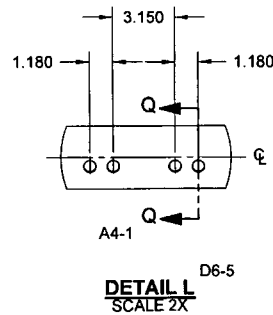
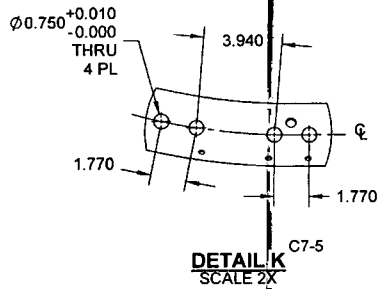
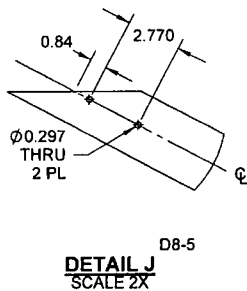
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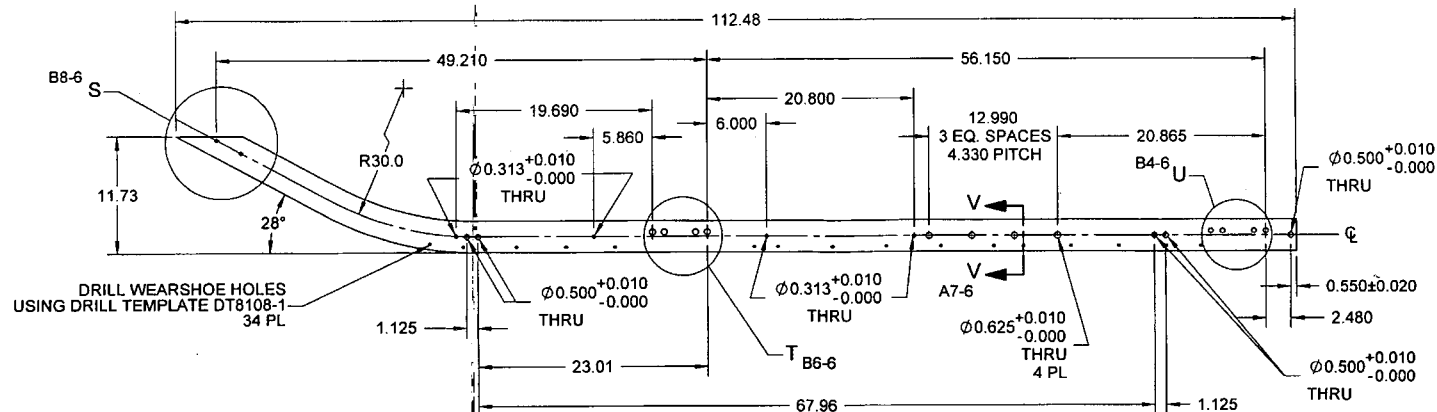
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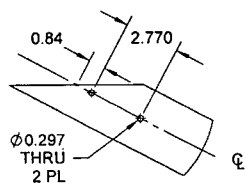
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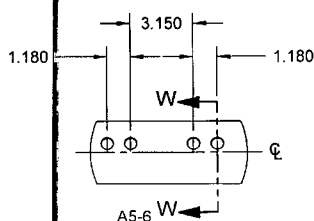
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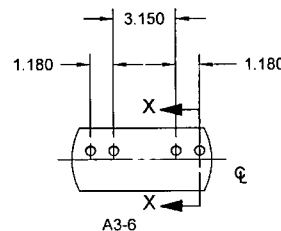
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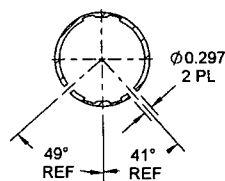
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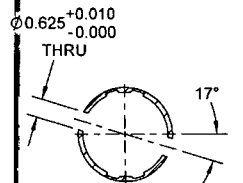
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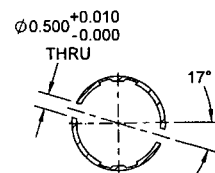
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

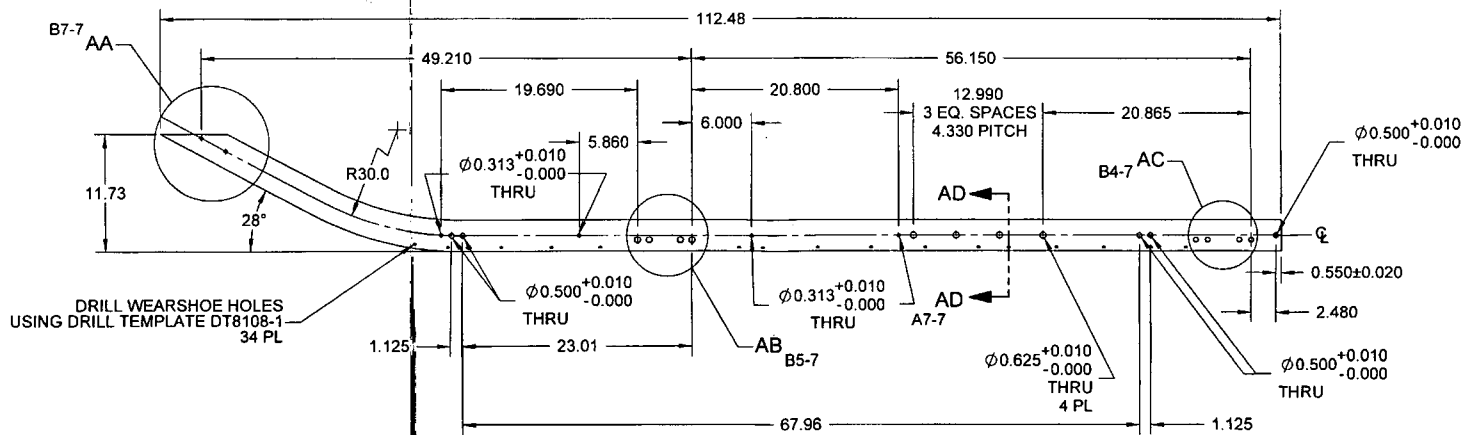


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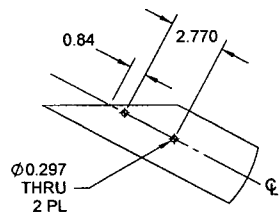
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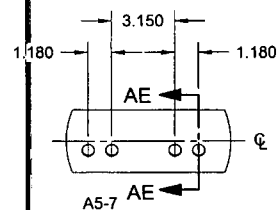
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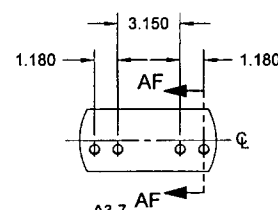
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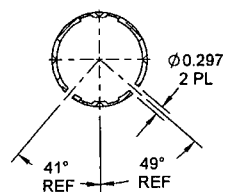
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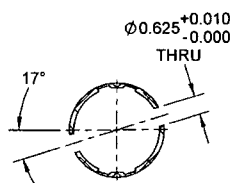
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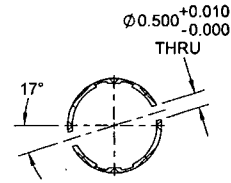
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

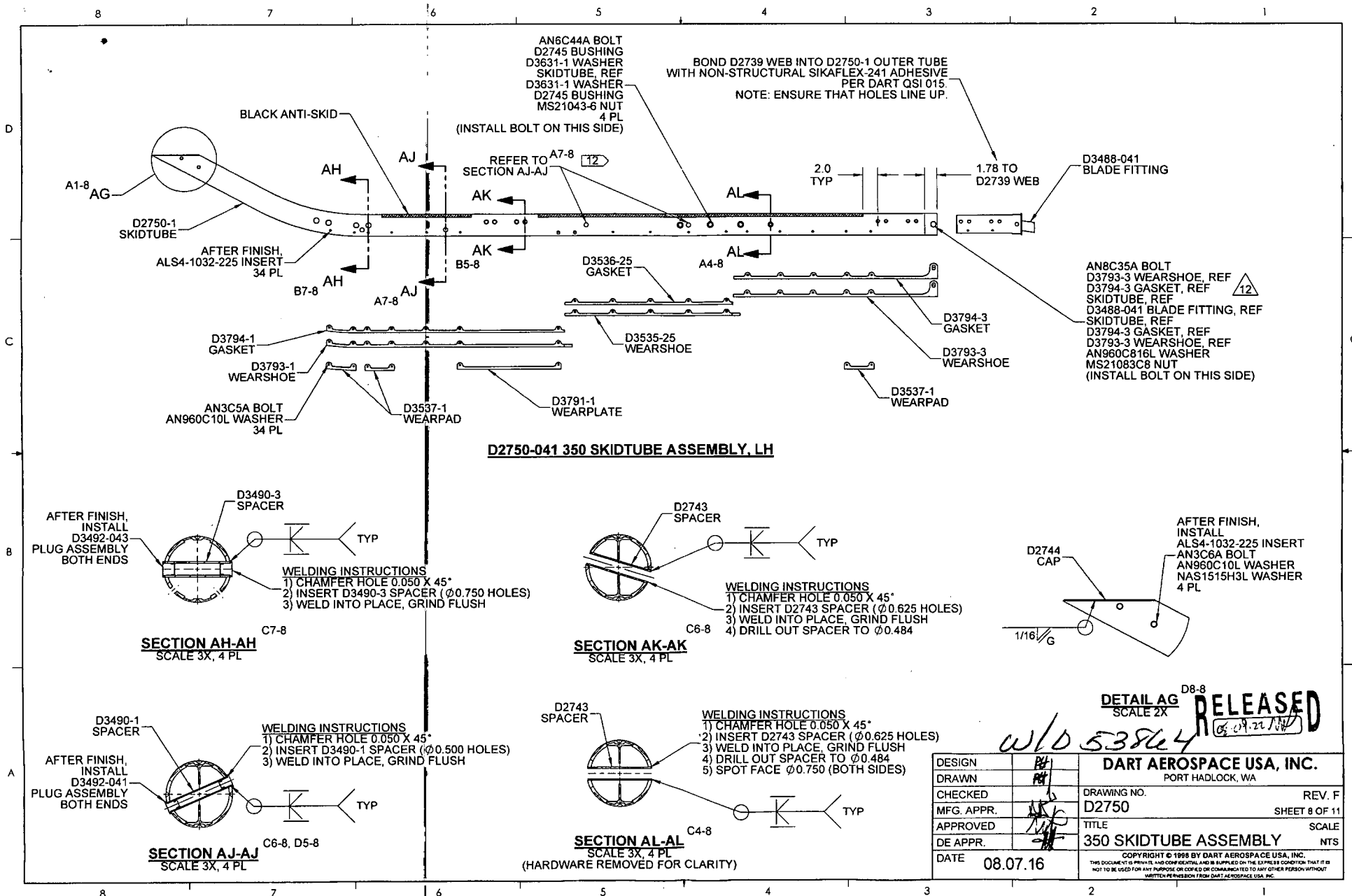


SECTION AF-AF
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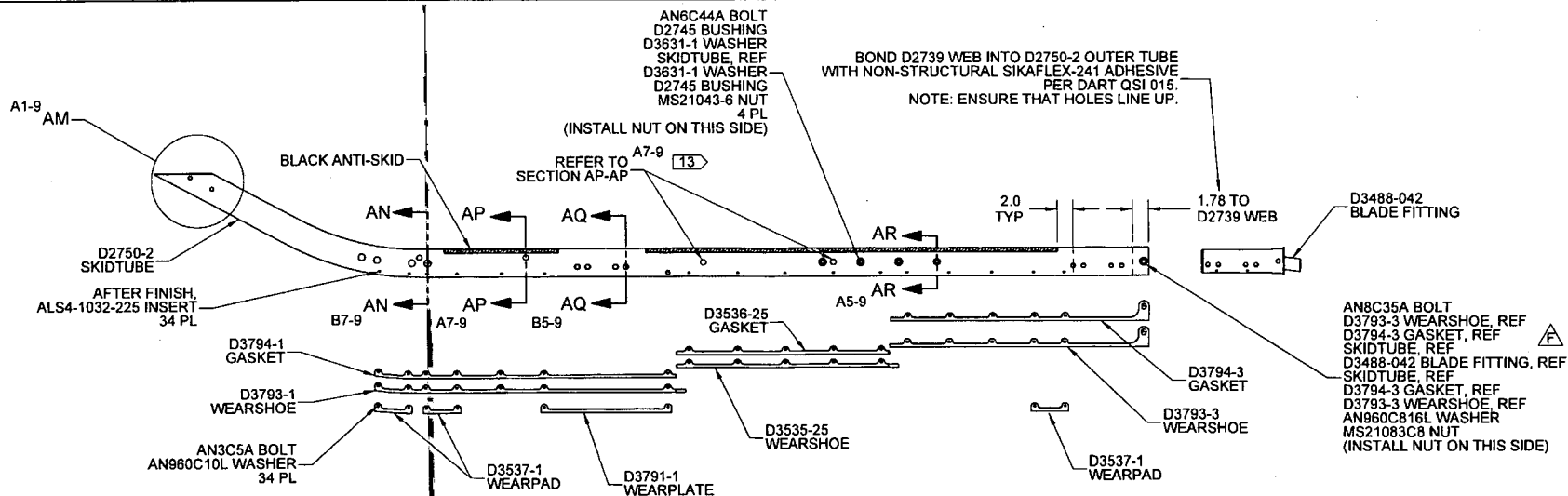
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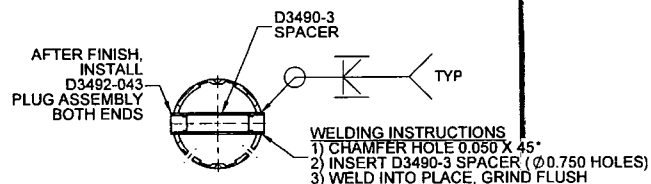
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CHECKED	S	DRAWING NO.	REV. F
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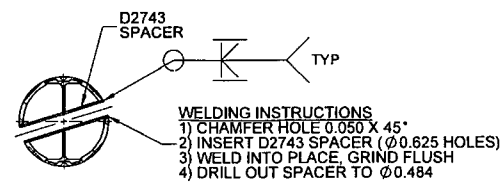
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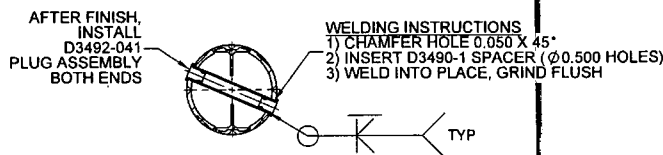
D2750-042 350 SKIDTUBE ASSEMBLY, RH



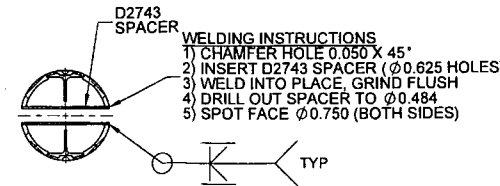
SECTION AN-AN
SCALE 3X, 4 PL



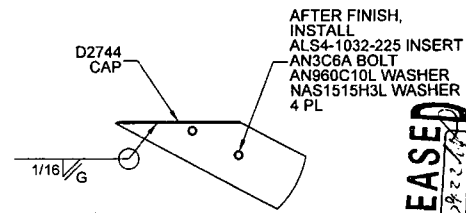
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



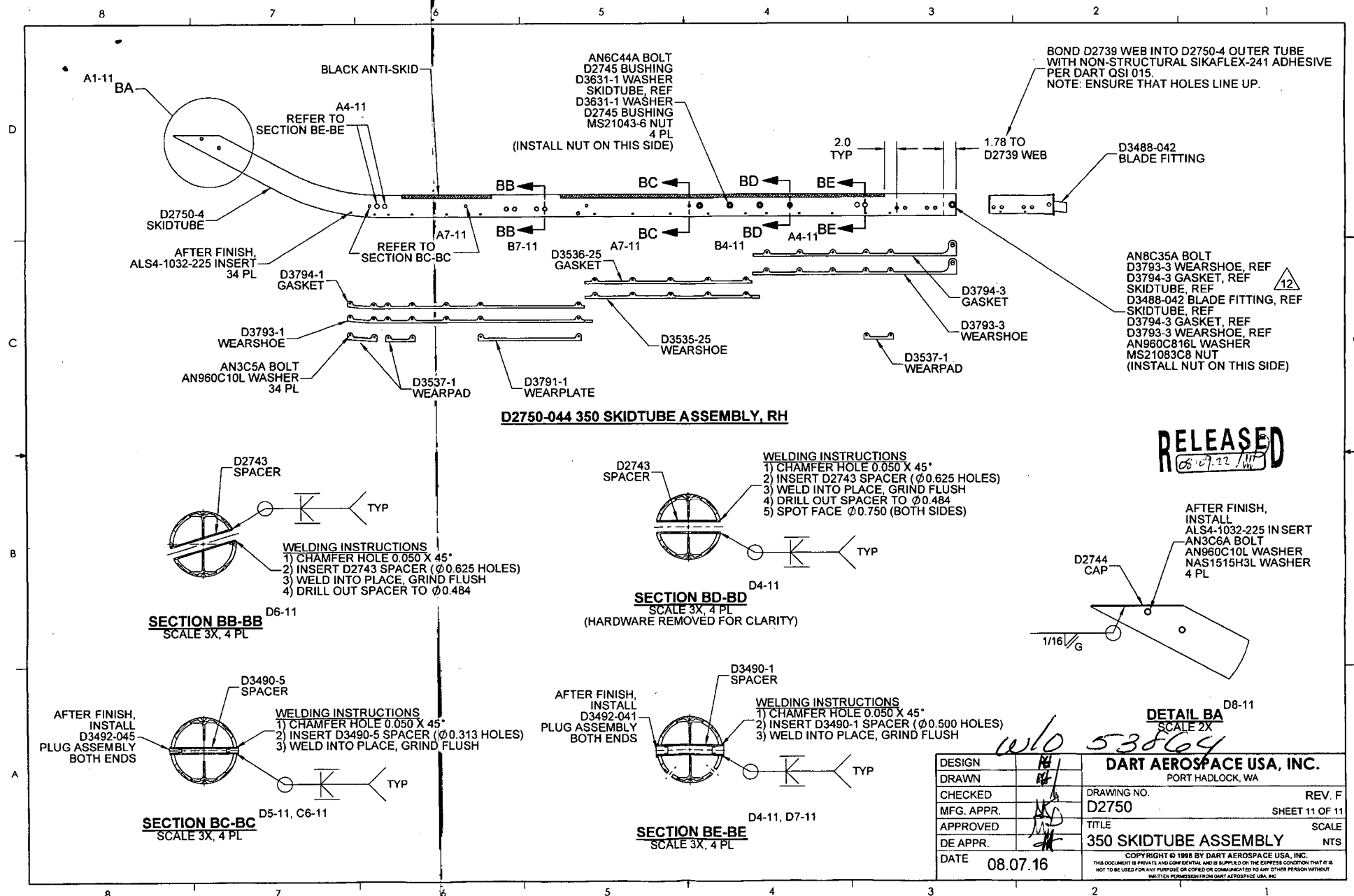
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F D2750 SHEET 9 OF 11 SCALE NTS
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
08-07-16



NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 051620
Part number: 1350-636-Q12
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Dwyer Date of Test Coupon 09/10/22
Welder Barclay Elliott Date of Test Coupon 09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld